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5000901

D3913-041
Job Sheet 166256



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D3913-041 Long Basket Base Assembly, 350	DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM		0.000	
AN3-10A Bolt			0.000	
D2581 Mounting Bracket	DWG REV A1 IPP D 01.07.17 Added info to step 2 SM		0.000	
D2931 Bumper	DWG REV A IPP B 01.06.27 Removed material certs., and added inspection Level 21 EC		0.000	
D3913-1 Rib	DWG REV D SHEET 6 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B add drill one side only DD 10.04.12 verified by:EC IPP Rev:C 11.01.18 chg qc5 to 6 DD verf:EC		0.000	
D3913-15 Wide Handle Plate	DWG REV D SHEET 5 IPP Rev:A new issue DD 10.03.19 verified by:EC		0.000	
D3913-3 Rib	DWG REV D SHEET 6 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B 11.02.04 chg qc5 to 6 DD verf:EC		0.000	
D3913-7 Rib	DWG REV D SHEET 6 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B 11.01.17 chg qc5 to 6 DD verf:EC		0.000	
D3913-9 Hinge Rib	DWG REV D SHEET 6 IPP Rev:A new issue DD 10.03.19 verified by:EC		0.000	
D3916-041 Rib Assembly	DWG REV A IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC		0.000	
D3916-5 Light Rib	DWG REV A IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC		0.000	
D4016-1 Hinge Half, Base	DWG REV B SHEET 1 IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B as per dwg REV.A DD 10.02.22 verified by:EC		0.000	
D4017-7 Rib	DWG REV F SHEET 6 IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 11.01.18 chg qc5 to 6 DD verf:EC		0.000	
D4017-9 Rib	DWG REV F SHEET 6 IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 11.01.17 chg qc5 to 6 DD verf:EC			
D4020-11 End Mesh, Basket	DWG REV A IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C 10.06.14 remove c be made when install on basket DD verf:JLM			
D4021-1 Handle Plate	DWG REV B SHEET 2 IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg REV.B DD 10.04.20 verified by:EC			

Status: Stock

Part: D3913-041 B166256

Created: 9/30/17 1:01 PM DART.MICHAUD-FEBRILLE.VICTORIA



Serial No: S000200

Printed By: Goldston, Justin 10/2/17 10:45 AM

D4021-5 Blanking Plate	DWG REV B SHEET 2 IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC	
D4034-041 Aft Upper Rib Assembly	DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS	0.000
D4034-043 Fwd Upper Rib Assembly	DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS	0.000
D4672-1 Blanking Plate	DWG REV A IPP REV:A NEW ISSUE 12-07-10 JLM VERIFIED BY:EC IPP REV:B 12.07.24 AS PER DWG REV.A DD VERF:EC	0.000
M304EX0.75-16F Expanded Metal Flat SS		0.000
MS20600-AD4W3 Cherry Rivet		0.000
MS21042L3 Nut	DWG REV A	0.000
NAS1149F0332P Washer		0.000

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/28/17	0.00	0.00	Start up container	
150	HandFinish	1 pcs	10/31/17	0.00	0.50	HandFinish4	
160	QC	1 pcs	10/31/17	0.00	0.00	QC5	
170	Packaging	1 pcs	10/31/17	0.00	0.00	Packaging3	
180	QC21-SA	1 Ea	10/31/17	0.00	0.00	QC21	ML5 17-10-24

Part Op
Descriptions: 150 - Pick Kit

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D3913-041 B166256		1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3913-041 B166256	1	1	0	0

Part Specifications

Specifications could not be found.

Work Order Summary

Thursday, September 28, 2017 8:53:16 AM

Page 1 of 3

Criteria : Work Order ID: 166256 Item ID: D3913-041 Product Family LARGE FAB
Work Order Start Dates 9/18/2017 to 9/18/2017 11:59:59 PM Work Order Required Dates 9/21/2017 to 9/21/2017 11:59:59 PM
All References
Work Order Status Released

Work Order ID	166256	Required Qty	1.0000	Status Code	Released
Item ID	D3913-041	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Long Basket Base Assembly, 350				
Current Acct Value	\$3,061.651				
Start Date	9/18/2017	Required Date	9/21/2017	Completed Date	
Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **	
<u>Direct Costs</u>	<u>Total</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>
Material	\$452.016	\$0.000	\$449.827	\$449.827	100.00%
Labor	\$773.963	\$0.000	\$583.848	\$583.848	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$1,645.010	\$0.000	\$1,256.373	\$1,256.373	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$2,870.989	\$0.000	\$2,290.048	\$2,290.048	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
AN3-10A Bolt	6.0000		9/28/2017	6.0000	\$0.600
D2581 Mounting Bracket	2.0000		9/14/2017	2.0000	\$11.188
D2931 Bumper	2.0000		9/25/2017	2.0000	\$0.100
D3913-1 Rib	1.0000		9/14/2017	1.0000	\$54.113
D3913-15 Wide Handle Plate	1.0000		9/14/2017	1.0000	\$3.918
D3913-3 Rib	1.0000		9/14/2017	1.0000	\$46.014
D3913-7 Rib	2.0000		9/14/2017	2.0000	\$47.781
D3913-9 Hinge Rib	1.0000		9/14/2017	1.0000	\$35.513
D3916-041 Rib Assembly	2.0000		9/14/2017	2.0000	\$312.825
D3916-5 Light Rib	3.0000		9/14/2017	3.0000	\$180.924

D4016-1				
Hinge Half, Base				
	3.0000	9/14/2017	3.0000	\$90.586
D4017-7				
Rib				
	3.0000	9/14/2017	3.0000	\$20.171
D4017-9				
Rib				
	2.0000	9/28/2017	1.0000	\$30.535
	2.0000	9/21/2017	1.0000	\$30.535
D4020-11				
End Mesh, Basket				
	2.0000	9/21/2017	2.0000	\$40.741
D4021-1				
Handle Plate				
	3.0000	9/14/2017	3.0000	\$13.401
D4021-5				
Blanking Plate				
	2.0000	9/25/2017	2.0000	\$11.338
D4034-041				
Aft Upper Rib Assembly				
	1.0000	9/21/2017	1.0000	\$174.479
D4034-043				
Fwd Upper Rib Assembly				
	1.0000	9/21/2017	1.0000	\$165.756
D4672-1				
Blanking Plate				
	2.0000	9/14/2017	2.0000	\$25.485
M304EX0.75-16F				
Expanded Metal Flat SS				
	33.0000	9/21/2017	33.0000	\$138.600
MS20600-AD4W3				
Cherry Rivet				
	2.0000	9/25/2017	2.0000	\$0.340
MS21042L3				
Nut				
	6.0000	9/25/2017	6.0000	\$0.840
NAS1149F0332P				
Washer				
	12.0000	9/25/2017	12.0000	\$0.136
NAS1149FN832P				
Washer				
	2.0000	9/25/2017	2.0000	\$0.027
Total Matl Amts:				\$1,435.943

125		0.00	0.00	0.28	0.28	1.00	\$0.000	\$6.107	\$15.243	\$0.000	\$21.350
Total:		0.00	0.00	0.56	0.56	2.00	\$0.000	\$12.207	\$30.470	\$0.000	\$42.677

Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
CRUI01												
	9/19/2017											
100			0.00	0.00	4.10	4.10	1.00	\$0.000	\$88.049	\$178.719	\$0.000	\$266.768
100			0.00	0.00	0.92	0.92	1.00	\$0.000	\$19.679	\$39.944	\$0.000	\$59.623
	9/20/2017											
100			0.00	0.00	1.82	1.82	1.00	\$0.000	\$39.177	\$79.521	\$0.000	\$118.698
100			0.00	0.00	5.13	5.13	1.00	\$0.000	\$110.349	\$223.982	\$0.000	\$334.331
JEAU01												
	9/20/2017											
100			0.00	0.00	3.92	3.92	1.00	\$0.000	\$84.340	\$171.191	\$0.000	\$255.531
100			0.00	0.00	3.65	1.82	2.00	\$0.000	\$39.211	\$79.588	\$0.000	\$118.799
	9/21/2017											
100			0.00	0.00	2.23	2.23	1.00	\$0.000	\$47.958	\$97.343	\$0.000	\$145.301
LABO01												
	9/14/2017											
100			0.00	0.00	0.13	0.13	1.00	\$0.000	\$2.705	\$5.490	\$0.000	\$8.195
100			0.00	0.00	0.37	0.37	1.00	\$0.000	\$7.871	\$15.977	\$0.000	\$23.848
Total:			0.00	0.00	22.26	20.43	10.00	\$0.000	\$439.339	\$891.755	\$0.000	\$1,331.094

Work Center Powdercoat

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
ROQU01												
	9/25/2017											
130			0.00	0.00	0.80	0.80	1.00	\$0.000	\$17.527	\$43.748	\$0.000	\$61.275
Total:			0.00	0.00	0.80	0.80	1.00	\$0.000	\$17.527	\$43.748	\$0.000	\$61.275

Work Order ID 166256***166256***

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Wednesday, September 13, 2017 1:03:43 PM

Item ID: D3913-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Base Assembly, 350
Start Date: 9/18/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/21/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:
Approvals: Process Plan:  Date: SEP 13 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	D								
D4020	A								
100	Weld per dwg A/R S.S. rod Batch: <u>138057</u>	0.00							
100	Large Fab								
Large Fab	Memo	3.18							
Large Fab	1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110	QC								
Quality Control	Memo	0.02							

 17.09.211 **SEP 22 2017** **DAS 24 9-89**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Work Order ID 166256***166256***

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Wednesday, September 13, 2017 1:03:43 PM

Item ID: D3913-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Basket Base Assembly, 350

Start Date: 9/18/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/21/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				1	SEP 22 2017		DAS 24 9-89
120									
QC	Memo	0.02							
Quality Control	-Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per QSI 044 6.4								
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.44							
Hand Finishing									

1 ϕ 1709-22 DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER :					

Work Order ID 166256

166256

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Wednesday, September 13, 2017 1:03:43 PM

Item ID: D3913-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Long Basket Base Assembly, 350
 Start Date: 9/18/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/21/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat M 13804 2-Mask this area prior to finish section E-E 3-1ST COAT: 9:00 START TIME: 9:00 375° OVEN TEMPERATURE: 375° FINISH TIME: 9:15 ***** 2nd coat if necessary ***** 2ND COAT: 10:55 START TIME: 10:55 375° OVEN TEMPERATURE: 375° FINISH TIME: 11:10	0.00 0.68				1	0	17-09-25	DAS 94 939
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				1	0	17/10/17	DAS 15 9-89

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→
last page

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Wednesday, September 13, 2017 1:03:43 PM

166256

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Long Basket Base Assembly, 350

Start Date: 9/18/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/21/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NB2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Assemble as per dwg

0.00

150

HandFinish

Memo

0.53

Hand Finishing

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.02

Quality Control

170

Identify as per dwg & Stock Location: w/o

0.00

170

Packaging

Memo

0.01

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 166256***166256***

Page 5

Wednesday, September 13, 2017 1:03:43 PM

Item ID: D3913-041**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Long Basket Base Assembly, 350**Start Date:** 9/18/2017 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 9/21/2017 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.10

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : ☐							

Picklist Print

Wednesday, September 13, 2017 1:03:41 PM

Work Order ID: 166256

166256

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 9/18/2017

Required Date: 9/21/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B
chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24
AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG
REV.C / ECN 13-624 DD VERF:JLM IPP Rev.E 17.06.12 As per Dwg.Rev
D DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	----------------	--------------	---------------	----------------	--------

NAS1149FN832P		Purchased	No			150	Each	4,346.000	2	2			
---------------	--	-----------	----	--	--	-----	------	-----------	---	---	--	--	--

NAS1149FN832P

Washer

Location	Loc Qty	Loc Code
GA	2479	
M137820	109	
M138336	2370	
ST263	1867	
M138336	1867	

DAS
6
SEP 25 2017

D3913-1		Manufactured	No			100	Each	2.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3913-1

Rib

Location	Loc Qty	Loc Code
WA004	2	166087
	2	

I D.M.L 2017-9-14

D3913-3		Manufactured	No			100	Each	5.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3913-3

Rib

Location	Loc Qty	Loc Code
WA004	5	164635
	1	
	4	166088

I D.M.L 2017-9-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation		Disposition			

Root Cause	FAULT CATEGORY		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐			

Picklist Print

Wednesday, September 13, 2017 1:03:41 PM

Work Order ID: 166256

166256

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 9/18/2017

Required Date: 9/21/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-7
D3913-7
Rib

Manufactured No

100 Each 6.0000 2 2

**

2 D.M.L 2017-9-14

Location

Loc Qty

Loc Code

WA004

6

165510

2

165510

6

✓ D3913-9
D3913-9
Hinge Rib

Manufactured No

100 Each 2.0000 1 1

**

2 D.M.L 2017-9-14

Location

Loc Qty

Loc Code

WA004

2

165909

2

165909

2

✓ D3916-5
D3916-5
Light Rib

Manufactured No

100 Each 10.0000 3 3

**

3 D.M.L 2017-9-14

Location

Loc Qty

Loc Code

WA004

10

165912

3

165912

10

✓ D3916-041
D3916-041
Rib Assembly

Manufactured No

100 Each 4.0000 2 2

**

2 D.M.L 2017-9-14

Location

Loc Qty

Loc Code

WA004

4

164947

2

164947

4

✓ D4017-7
D4017-7
Rib

Manufactured No

100 Each 27.0000 3 3

**

3 D.M.L 2017-9-14

Location

Loc Qty

Loc Code

WA004

27

165913

3

165913

27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

Picklist Print

Wednesday, September 13, 2017 1:03:42 PM

Page 3

Work Order ID: 166256

166256

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 9/18/2017

Required Date: 9/21/2017

Start Qty: 1.00

Required Qty: 1.00

D4017-9 Manufactured No

100 Each

0.0000 2 2

D4017-9

Rib

D4034-041 Manufactured No

100 Each

0.0000 1 1

D4034-041

Aft Upper Rib Assembly

D4034-043 Manufactured No

100 Each

0.0000 1 1

D4034-043

Fwd Upper Rib Assembly

D2581 Manufactured No

100 Each

36.0000 2 2

D2581

Mounting Bracket

Location

Loc Qty

Loc Code

WA004

36

162923

2

161800

6

162923

2

164446

28

D2931 Manufactured No

150 Each

1,236.000 2 2

D2931

Bumper

Location

Loc Qty

Loc Code

ST013

138

86435

138

ST025A

1098

86435

1098

D3913-15 Manufactured No

100 Each

14.0000 1 1

D3913-15

Wide Handle Plate

Location

Loc Qty

Loc Code

WA004

14

161938

1

161938

14

Wednesday, September 13, 2017 1:03:42 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, September 13, 2017 1:03:42 PM

Work Order ID: 166256

166256

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 9/18/2017

Required Date: 9/21/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D4016-1
Hinge Half, Base

Manufactured No

100 Each 19.0000 3 3

** 3 D.M.L 2017-9-14

Location

Loc Qty

Loc Code

WA004

19

159537 2

158630

3

159537

16

✓ D4021-1
Handle Plate

Manufactured No

100 Each 1.0000 3 3

** 3 D.M.L 2017-9-14

Location

Loc Qty

Loc Code

WA004

1

161473 3

161473

1

✓ D4021-5
Blanking Plate

Manufactured No

100 Each 7.0000 2 2

** SEP 25 2017

Location

Loc Qty

Loc Code

ST068

7

2

163689

7

✓ D4020-11
End Mesh, Basket

Manufactured No

100 Each 4.0000 2 2

** B163702 → 2, 17-09-21

Location

Loc Qty

Loc Code

WA004

4

163702

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Page 5

Wednesday, September 13, 2017 1:03:42 PM

Work Order ID: 166256

166256

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 9/18/2017

Required Date: 9/21/2017

Start Qty: 1.00

Required Qty: 1.00

D4672-1 Manufactured No

100 Each

12.0000 2 2

**

2 D.M.L 2017-9-14

D4672-1

Blanking Plate

Location

Loc Qty

Loc Code

WA004

12

165343 2
163201 1

~~163701~~
~~165343~~
165600

2
4
6

M304EX0.75-16F

Purchased

No

100 sf

503.9221 33 33

**

B138390 33 17-09-

M304EX0 75-16F

Expanded Metal Flat SS

Location

Loc Qty

Loc Code

WA004

503.9221052

M137765

9.29473684

M138128

14.6273684

M138390

480

MS20600-AD4W3

Purchased

No

150 Each

147.0000 2 2

**

SEP 25 2017

DAS
6
9-80

MS20600-AD4W3

Cherry Rivet

Location

Loc Qty

Loc Code

ST308

47

m135603

9

m137412

38

WA003

100

m137412

100

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, September 13, 2017 1:03:42 PM

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Work Order ID: 166256

166256

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 9/18/2017

Required Date: 9/21/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,533.000

6

6

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

SEP 25 2017

FP001

44

m135945

44

GA

308

m134360

102

M136665

206

OVER007

500

m138408

500

ST303

681

m138230

500

m138326

181

NAS1149F0332P

Purchased

No

150

Each

1,361.000

12

12

NAS1149F0332P

**

Washer

Location

Loc Qty

Loc Code

SEP 25 2017

GA

77

m133709

77

ST262

1284

m138209

1284

AN3-10A

Purchased

No

150

Each

160.0000

6

6

AN3-10A

**

Bolt

Location

Loc Qty

Loc Code

SEP 25 2017

GA

38

m136787

38

ST349

122

m138326

122

Wednesday, September 13, 2017 1:03:42 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____

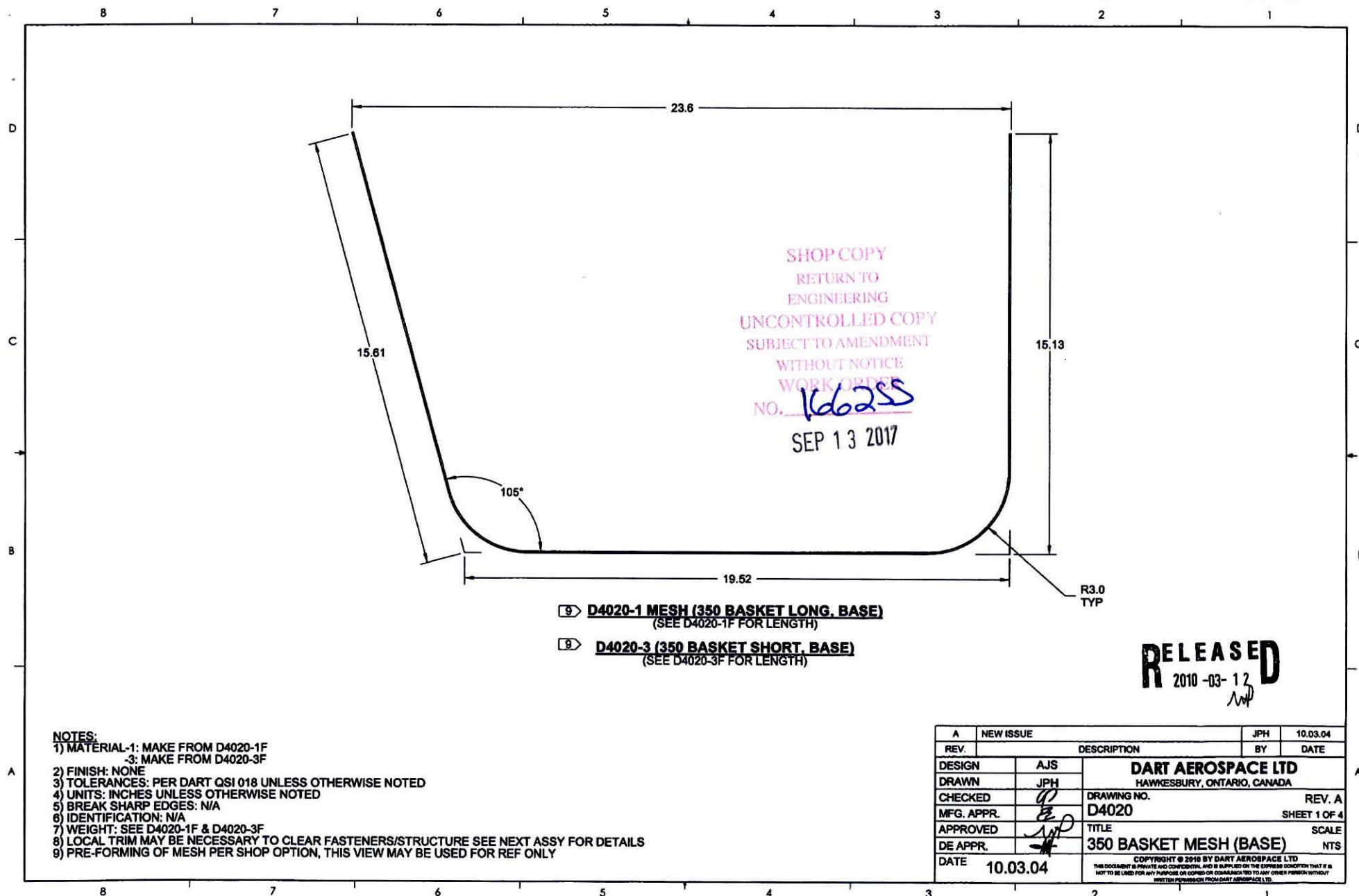


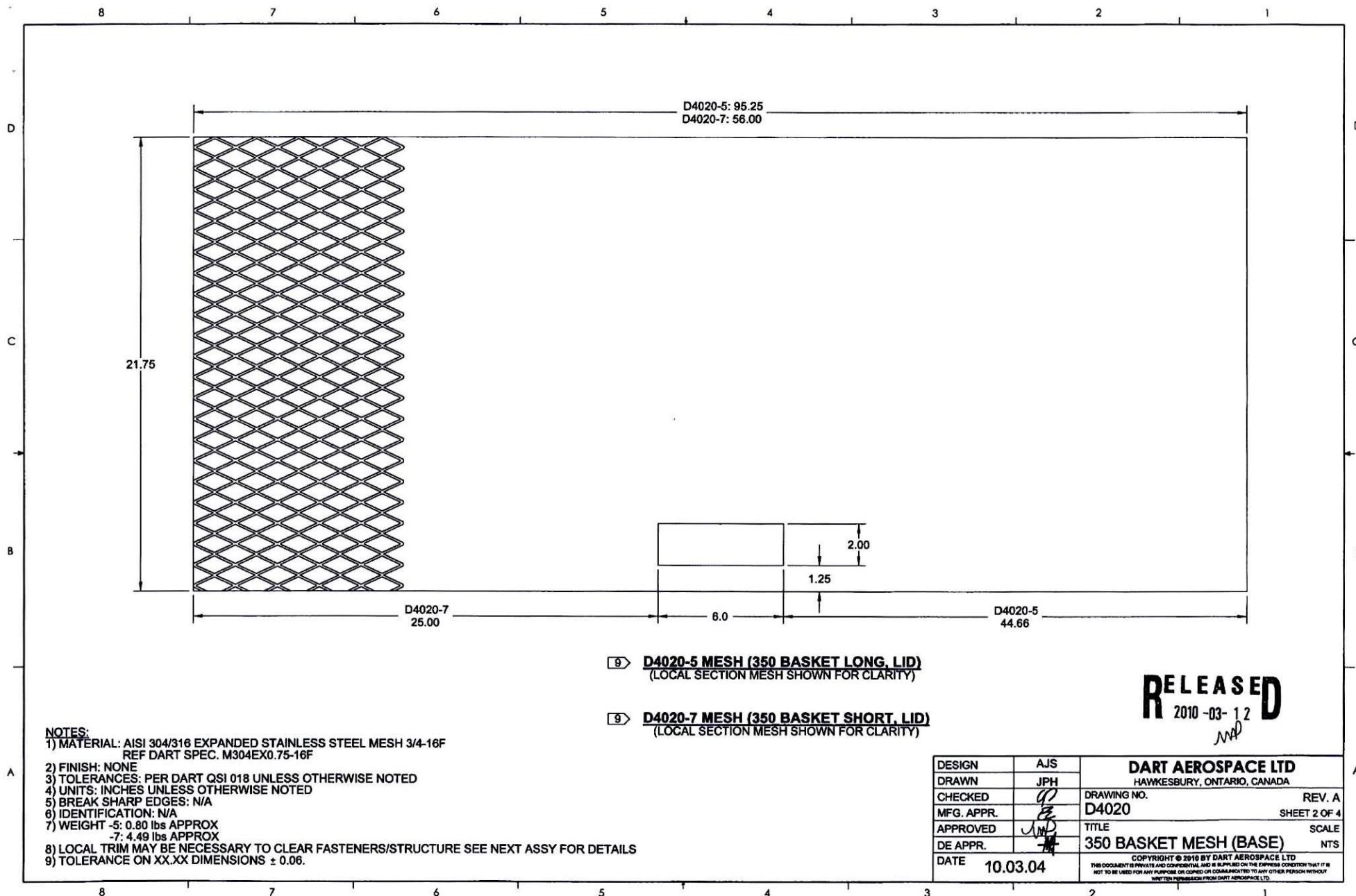
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																





9) **D4020-5 MESH (350 BASKET LONG, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9) **D4020-7 MESH (350 BASKET SHORT, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:

1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT -5: 0.80 lbs APPROX

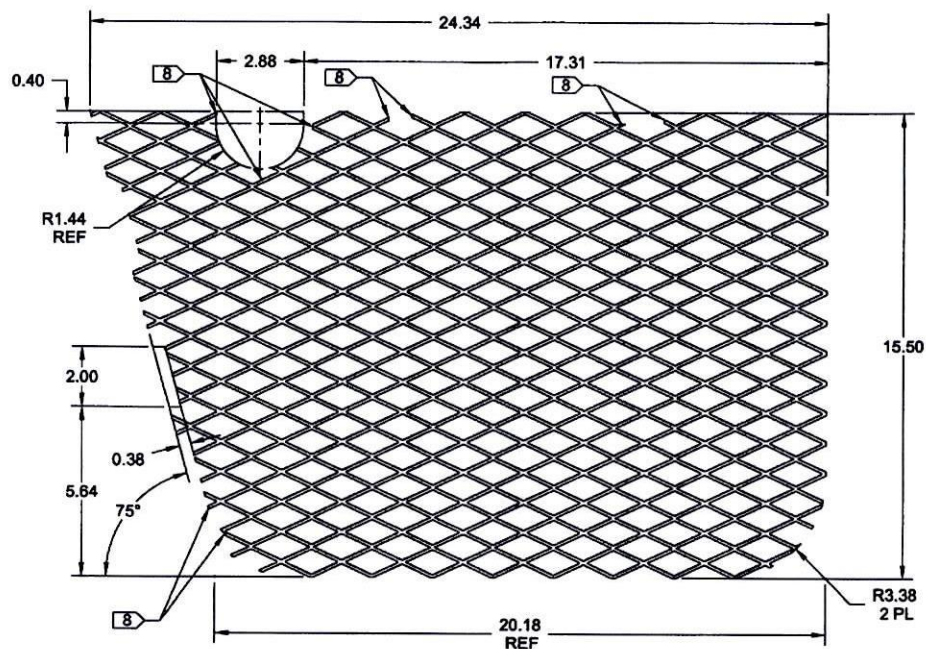
-7: 4.49 lbs APPROX

8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS

9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
NJP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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9) D4020-11 END MESH, BASKET

NOTES:

1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

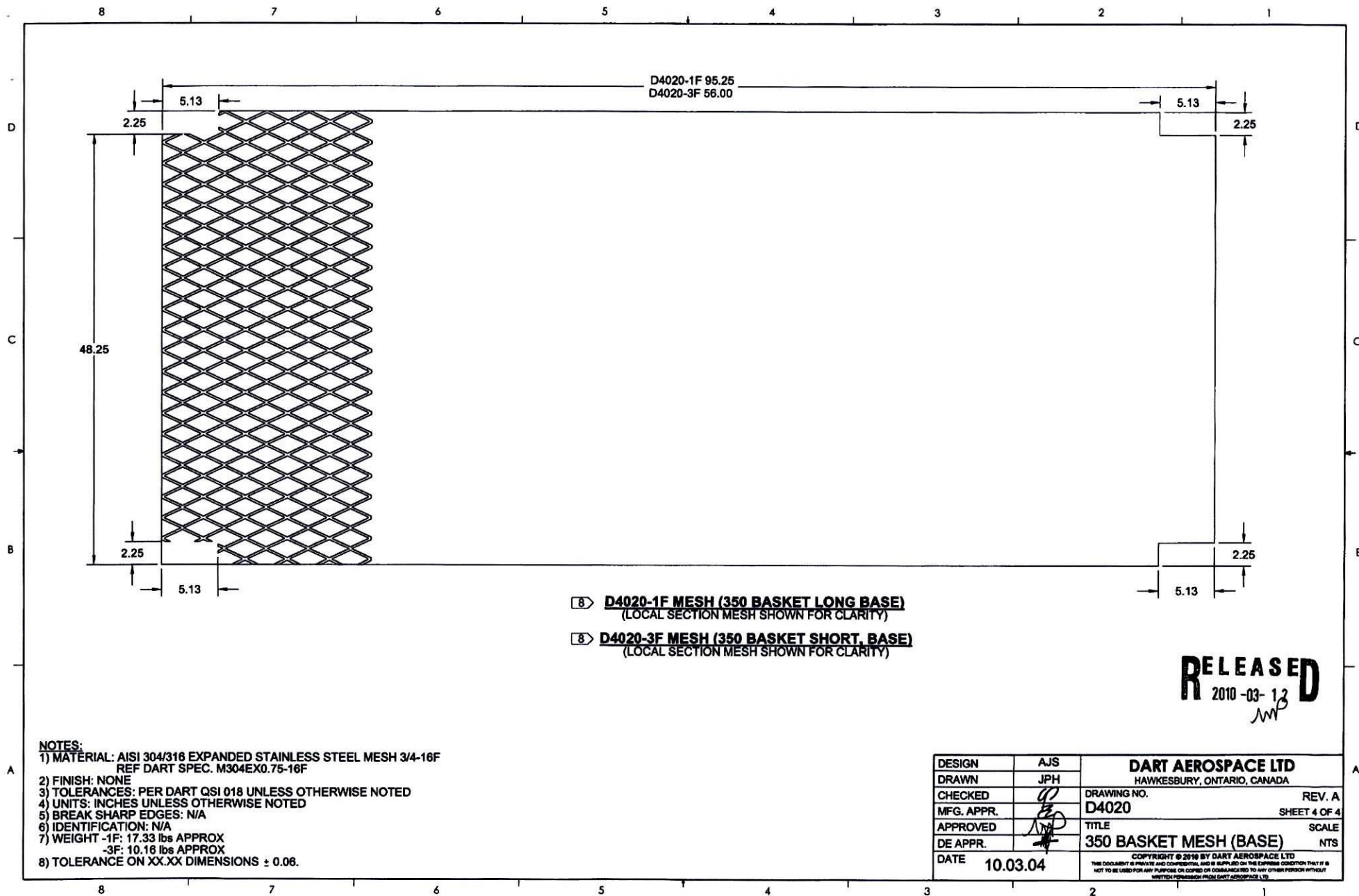
7) WEIGHT: 1.22 lbs

8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS

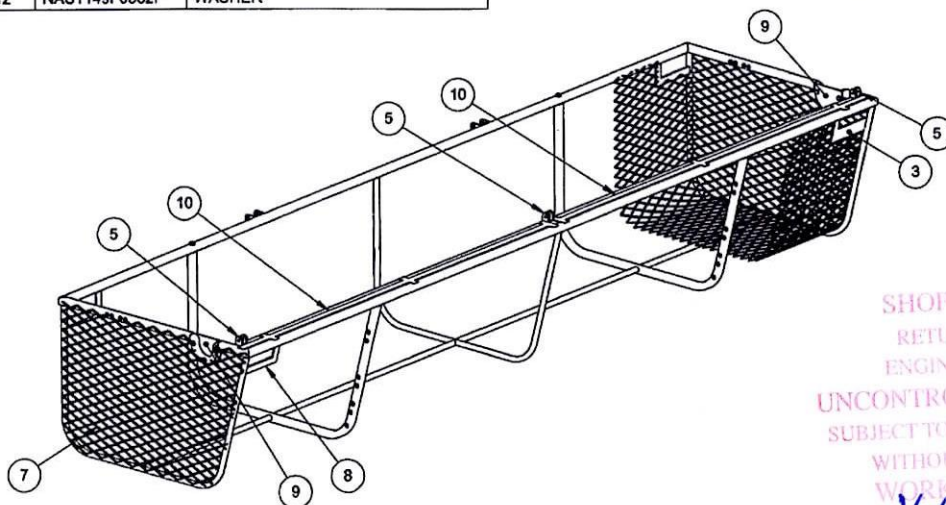
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
JMD

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	MS20600AD4W3	RIVET, BLIND
13	6	MS21042L3	NUT, SELF-LOCKING
14	2	NAS1149FN832P	WASHER
15	12	NAS1149F0332P	WASHER

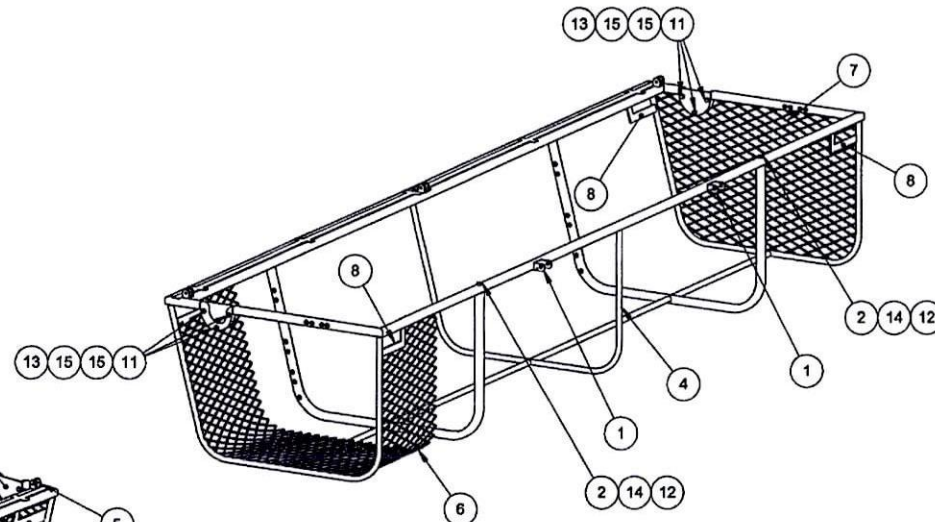


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166256

SEP 13 2017

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004
- 11) MASK THIS AREA PRIOR TO FINISH

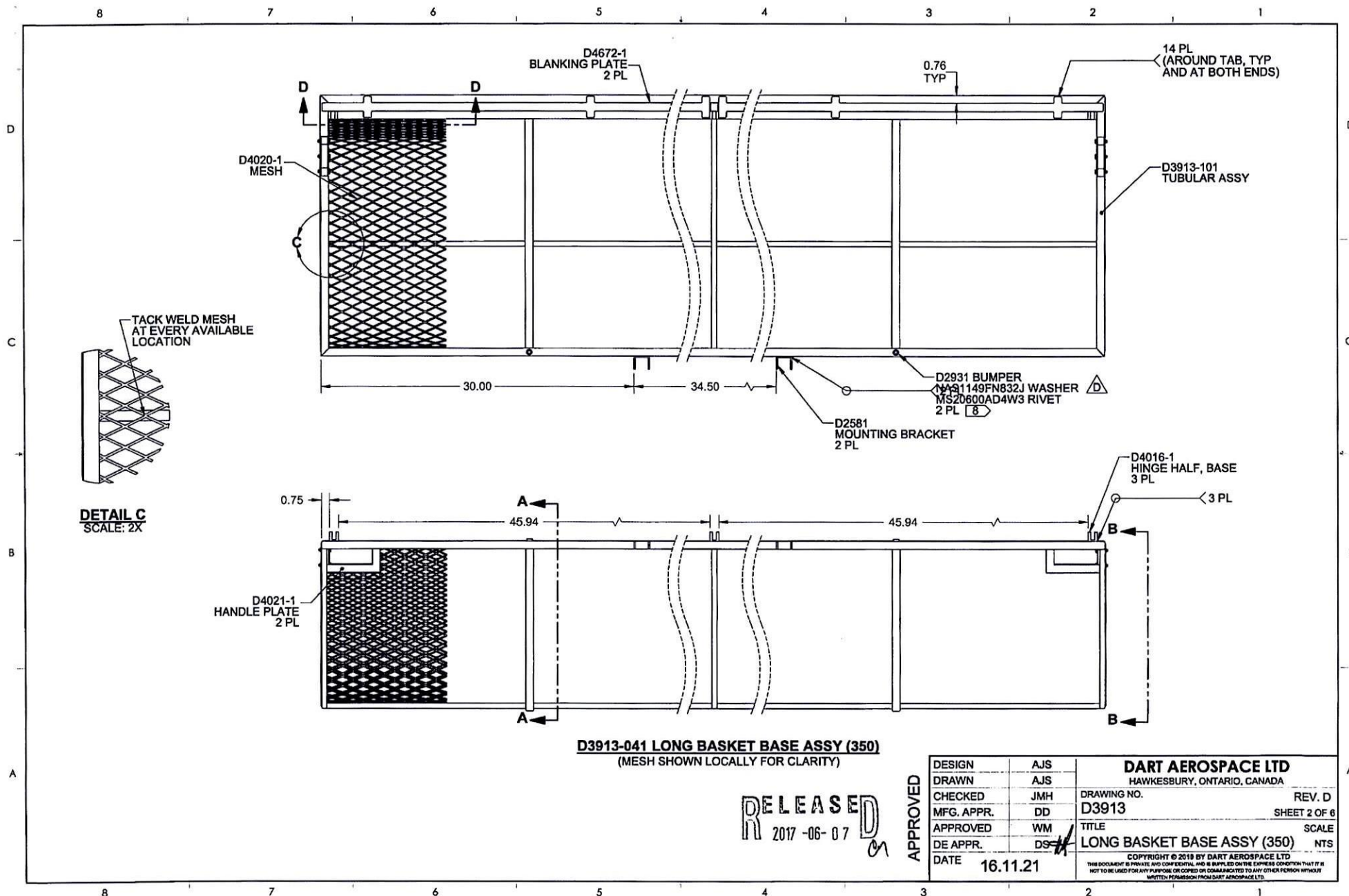


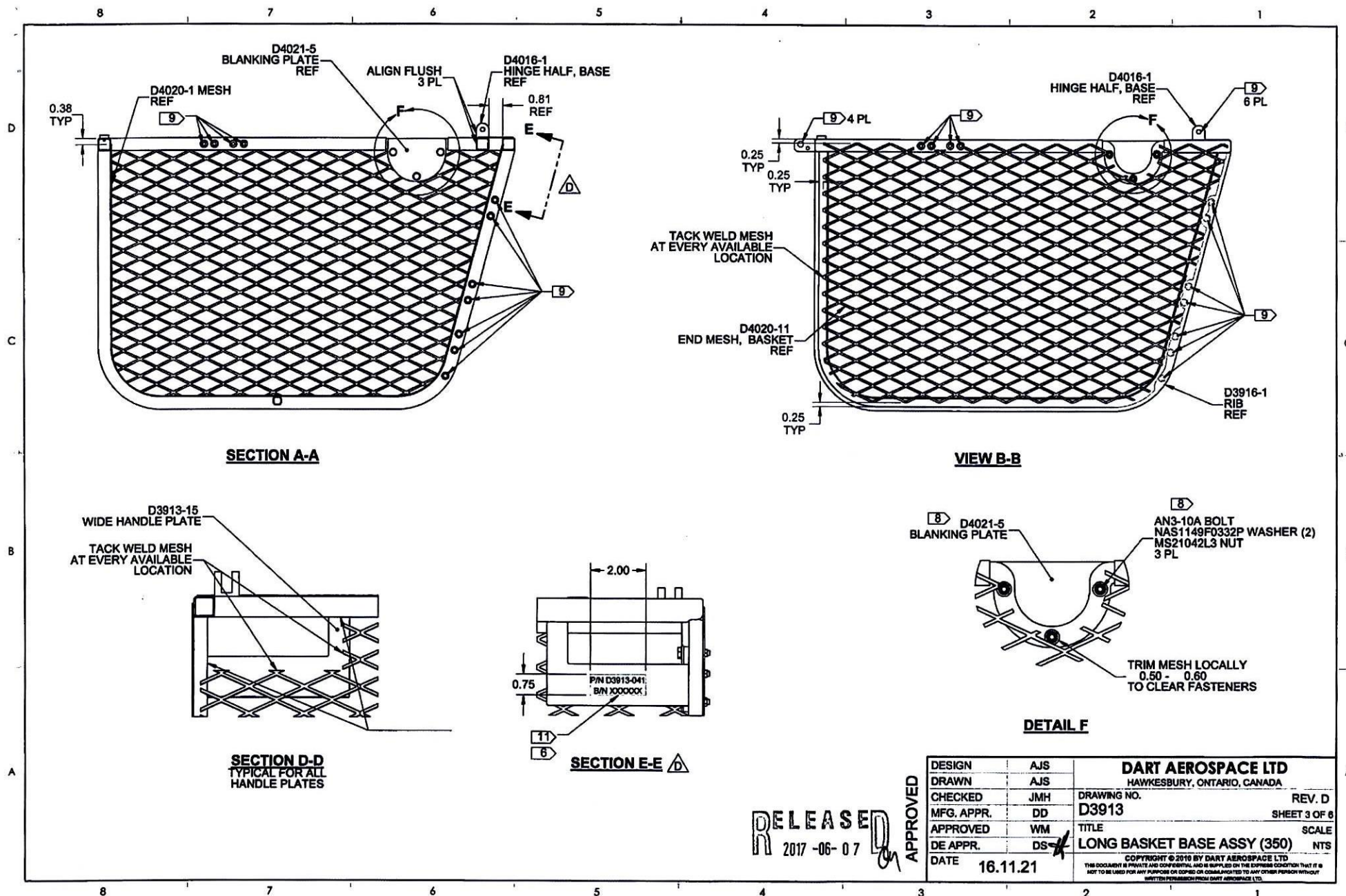
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D	ALL DETAIL/SECTION VIEW LETTERS UPDATED. SHEET 1: ITEM 14 WAS AN860JD8, UPDATED NOTE 6, ADDED NOTE 11. SHEET 3 ADDED VIEW E-E. (PAR15-418)	AJS	16.11.21
C	PICTORIAL UPDATES TO MULTIPLE SHEETS FOR CHANGES TO D4034-043 (REASON REMOVAL OF PROP ARM OPTION). D5-4 ADDED 2 MORE D4017-7 RIBS TO PREVENT BOWING. MULTIPLE DIMENSIONS RE-TOLERANCED FOR EASE OF MANUFACTURE. SECTION F-F & G-G ADDED.	AJS	13.07.18
B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PAR12-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3913	SHEET 1 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	D3	LONG BASKET BASE ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

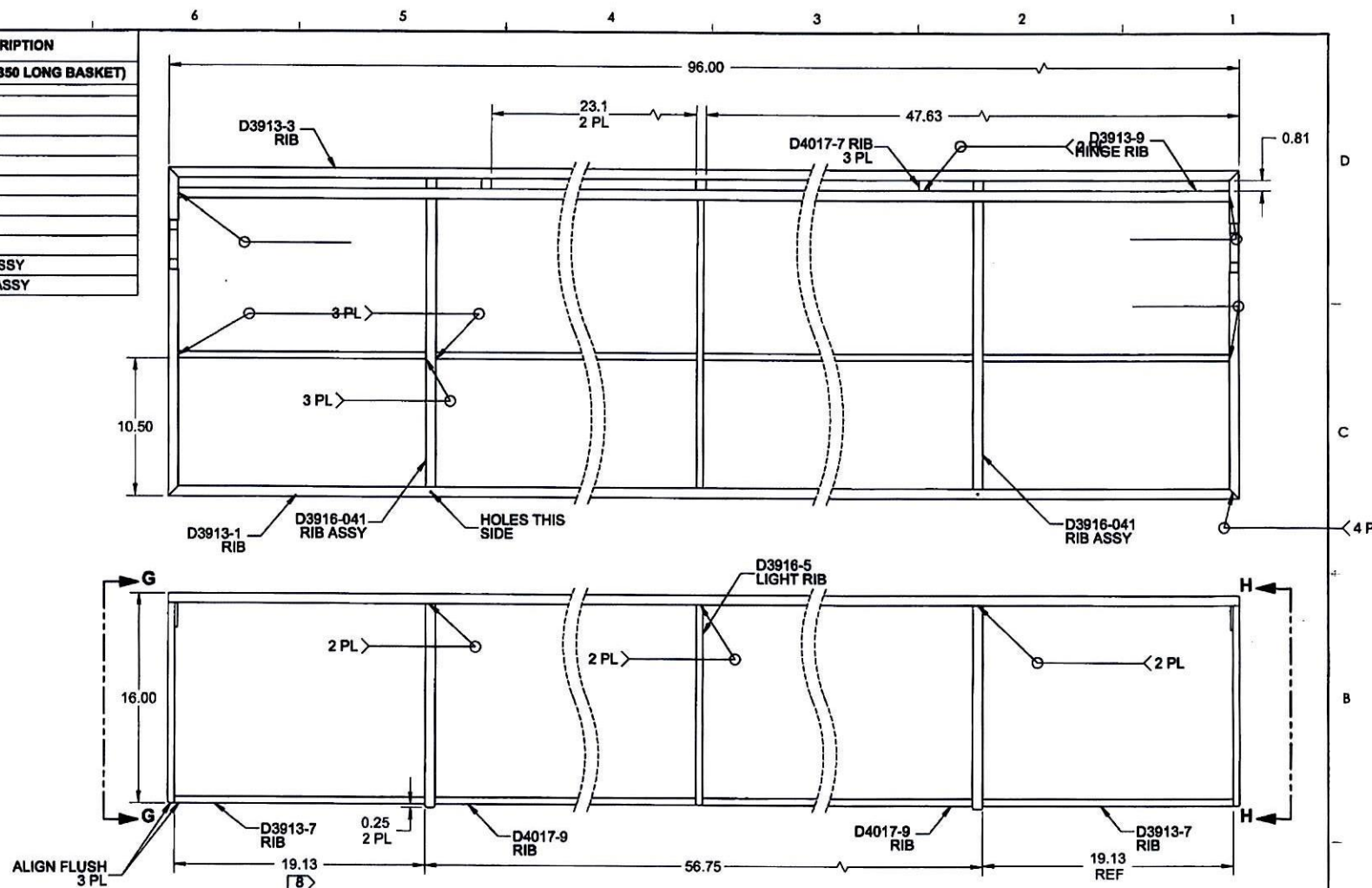
RELEASED
2017-06-07
EN 17-580

APPROVED





ITEM	QTY -101	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	3	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



D3913-101 TUBULAR ASSY (350 LONG BASKET)

NOTES:

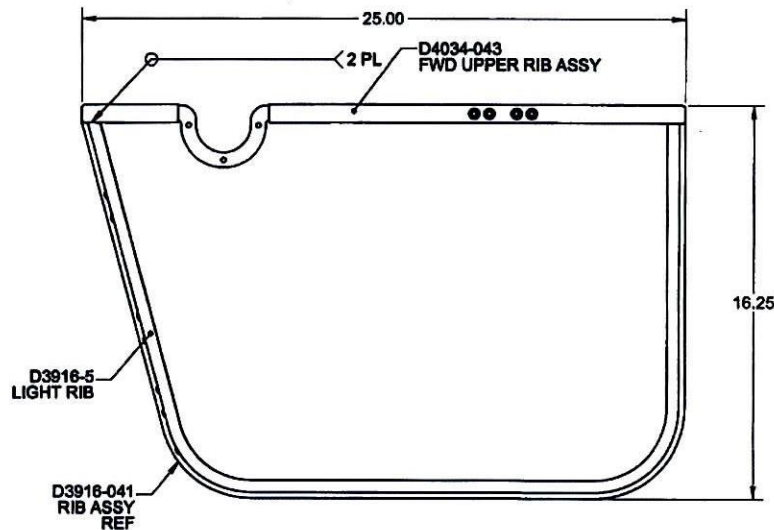
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.65 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

RELEASED
2017-06-07

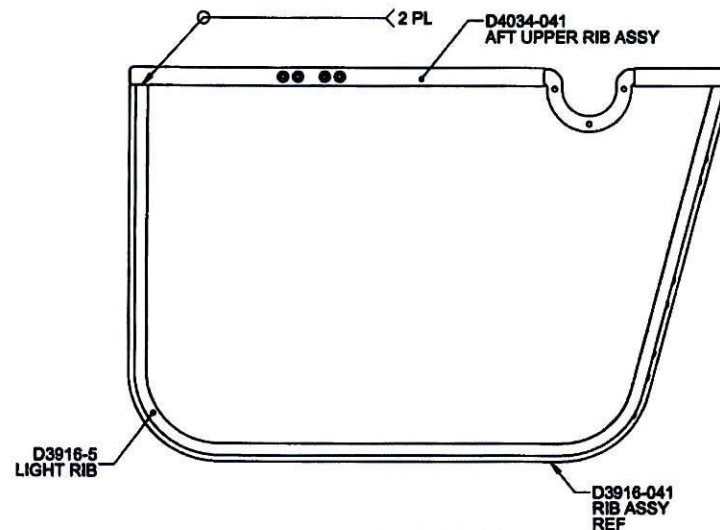
APPROVED

DESIGN	AJS
DRAWN	AJS
CHECKED	JMH
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	16.11.21

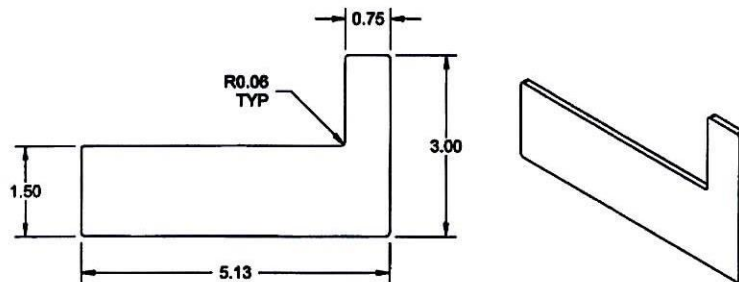
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3913	REV. D
TITLE LONG BASKET BASE ASSY (350)	SHEET 4 OF 6
SCALE NTS	
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SECTION G-G
SCALE 2X



SECTION H-H
SCALE 2X



D3913-15 WIDE HANDLE PLATE

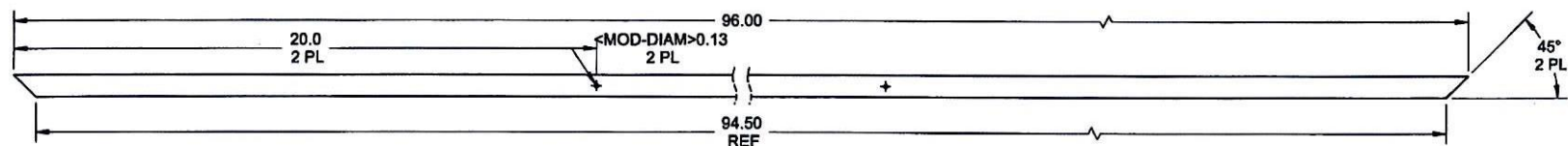
NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.125 THICK
PER MIL-S-5059 OR AMS 5613/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

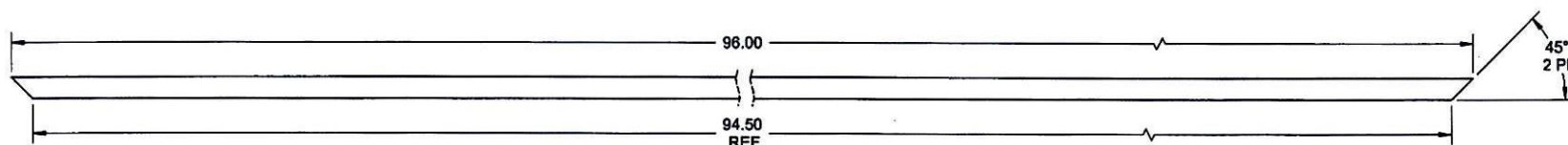
RELEASED
2017-06-07

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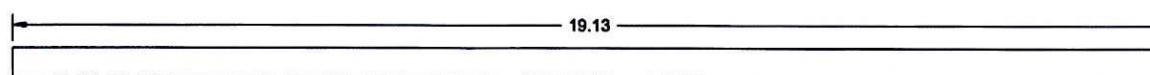
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3913	SHEET 6 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET BASE ASSY (350)	NTS
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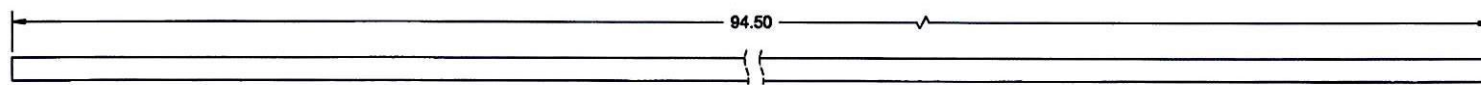
D3913-1 RIB



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2017-06-07

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3913	SHEET 6 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DSC	LONG BASKET BASE ASSY (350)	NTS
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Work Order NCR

Reviewed
DQA:
Date:

Printed on: Tuesday, September 26, 2017

Details			
Raised Date 9/26/2017	Status Open	Owner Menard, Jean-Luc	Number NCR17-6621
Target Date 9/27/2017	Standard	Severity	
Process Inspection		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier)		Fault Category General/Finish
Details finish to be found not exceptable. see attach picture			
Keywords		Product D350-607/D3913-041	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Root Cause			
Target Date 10/6/2017	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	

Corrective Action			
Target Date 10/6/2017	Owner Menard, Jean-Luc	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	
1	Menard, Jean-Luc	9/27/2017	
buff all affected area making sure there is no "high spot" before paint			
2	Menard, Jean-Luc	9/28/2017	
clean and make sure basket is clear of any dust or debris powder coat at 375 for 15min			

Implementing Corrective Action

Target Date	Owner	Closed Date	Closed By
10/13/2017	Menard, Jean-Luc		
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

Verification & Review

Target Date	Owner	Closed Date	Closed By
	Downing, Eric M		
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	